

The Claims:

This listing of claims will replace all prior versions, and listings, of claims in the application:

Listing of Claims:

Claim 1 (Original): A cartridge containing one or more beverage ingredients and being formed from substantially air- and water-impermeable materials, the cartridge comprising an outer member defining a storage chamber in which is stored the one or more beverage ingredients, an inner member having a discharge spout forming an outlet for outflow of beverage formed from the one or more beverage ingredients, and a filter disposed between the storage chamber and the discharge spout, characterised in that the inner member and filter are conjoined in one operation to the outer member by means of at least one weld.

Claim 2 (Original): A cartridge as claimed in claim 1 wherein the outer member has an opening for accessing the storage chamber, wherein the inner member and filter are conjoined to the outer member at a base remote from the opening.

Claim 3 (Original): A cartridge as claimed in claim 2 wherein the inner member, outer member and filter are annular.

Claim 4 (Original): A cartridge as claimed in claim 3 wherein the weld is substantially circular.

Claim 5 (Original): A cartridge as claimed in claim 4 wherein the inner member and outer member are of plastics materials and the at least one weld is an ultrasonically-formed weld.

Claim 6 (Original): A cartridge as claimed in claim 5 wherein the inner member comprises a frame and the at least one weld is formed round a periphery of said frame.

Claim 7 (Original): A cartridge as claimed in claim 6 wherein the frame comprises a plurality of webs extending upwardly from the frame towards a closed first end of the outer member to define one or more passages between the frame and the closed first end of the outer member and wherein welds are formed between the webs and the closed first end of the outer member.

Claim 8 (Withdrawn): A method of manufacturing a cartridge containing one or more beverage ingredients and being formed from substantially air- and water-impermeable materials, the cartridge comprising an outer member defining a storage chamber in which is stored the one or more beverage ingredients, an inner member having a discharge spout forming an outlet for outflow of beverage formed from the one or more beverage ingredients, and a filter, the method comprising conjoining the inner member and the filter in one step to the outer member by means of at least one welding step.

Claim 9 (Withdrawn): A method as claimed in claim 8 wherein the welding step is by ultrasonic welding.

Claim 10 (Withdrawn): A method as claimed in claim 9 further comprising forming a first welding line around a periphery of the inner member and filter.

Claim 11 (Withdrawn): A method as claimed in claim 10 further comprising forming a second welding line around the inner member and filter at or near the discharge spout.

Claim 12 (New): A cartridge as claimed in claim 1 wherein the at least one weld is a continuous weld.

Claim 13 (New): A cartridge as claimed in claim 1 wherein a secondary weld is formed between the discharge spout of the inner member and the outer member.

Claim 14 (New): A cartridge as claimed in claim 1 wherein the inner member is disposed between the filter and the outer member.

Claim 15 (New): A cartridge as claimed in claim 1 wherein the inner member comprises a frame and the at least one weld is formed round a periphery of said frame, the frame being disposed between the filter and the outer member, the frame having a plurality of webs extending upwardly from the frame towards a closed first end of the outer member to define one or more passages between the frame and the closed first end of the outer member and wherein welds are formed between the webs and the closed first end of the outer member.

Claim 16 (New): A cartridge as claimed in claim 15 wherein a secondary weld is formed between the discharge spout of the inner member and the outer member.

Claim 17 (New): A cartridge containing one or more beverage ingredients and being formed from substantially air- and water-impermeable materials, the cartridge comprising:

an outer member defining a storage chamber in which is stored the one or more beverage ingredients;

an inner member having a discharge spout forming an outlet for outflow of beverage formed from the one or more beverage ingredients;

a filter disposed between the storage chamber and the discharge spout, the inner member and filter are conjoined in one operation to the outer member by means of at least one weld;

an opening of the outer member for accessing the storage chamber, the opening being surrounded by a peripheral rim, and the inner member and filter are conjoined to the outer member at a base remote from the opening;

a lid covering the opening of the outer member, the lid being conjoined to the peripheral rim of the outer member by means of at least one weld.

Claim 18 (New): A cartridge as claimed in claim 17 wherein a secondary weld is formed between the discharge spout of the inner member and the base of the outer member.

Claim 19 (New): A cartridge as claimed in claim 18 wherein a manifold substantially surrounds the interior of the outer member adjacent the opening, a majority portion of the manifold being separated from the storage chamber by a manifold wall having a plurality of openings permitting flow from the manifold to the storage chamber, and the lid being conjoined to the manifold wall by means of at least one weld.

Claim 20 (New): A cartridge as claimed in claim 19 wherein the lid is conjoined to an end of the discharge spout opposite the secondary weld by means of at least one weld.

Claim 21 (New): A cartridge as claimed in claim 20 wherein the manifold has an inlet chamber, the inlet chamber of the manifold bounded in part by an inlet wall separating the inlet chamber from the storage chamber, the inlet chamber having a width larger than that of the manifold, and the lid being conjoined to the inlet wall by means of at least one weld.